

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84038

Tuesday, May 01, 2012 1:00:59 PM

84038

Page 2

Item ID: D212-725-1-153F

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Support Angle Oil Cooler

Stop

NS2

Start Date: 5/1/2012 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 5/4/2012 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--	----------------------------------	------------------------------	----------------	---------------	----------------------	-----------------------	-----------------------	--------------------------	------------------------

120	QC8- Inspect parts - second check	0.00							
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120

QC

Quality Control

0.00

5/1/2012

77

130

130

Brake NC

Brake NC

Bend as per dwg

0.00

Memo

0.00

N
A
MFT 12-05-01

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

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NS1

Revision ID:

Item Name: Support Angle Oil Cooler

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Start Date: 5/1/2012 **Start Qty:** 1.00

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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00				3	00	1205/02	
	Memo	0.00							
160 *160* QC	QC3- Inspect Part Finish	0.00				3x	0	1205/08	
	Memo	0.00							
170 *170* Packaging	Identify as per dwg & Stock Location <u>B84</u>	0.00				3x	0	1215/380	
	Memo	0.00							

Dart Aerospace Ltd

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Tuesday, May 01, 2012 1:00:59 PM

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Item ID: D212-725-1-153F

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Support Angle Oil Cooler

Stop

NS2

Start Date: 5/1/2012 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 5/4/2012 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
						Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC	QC2I- Final Inspection - Work Order Release	0.00							12/5/4 J
	Memo	0.00							

MF
12-05-03

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Picklist Print

Tuesday, May 01, 2012 1:00:59 PM

Page 1

Work Order ID: 84038

Parent Item: D212-725-1-153F

Start Date: 5/1/2012

Required Date: 5/4/2012

Parent Item Name: Support Angle Oil Cooler

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	219.4312	0.2416	0.2543158			

Location	Loc Qty	Loc Code
MAT022	219.4311626	
117684	21.318421	
120196	37.35	
120605	64.7627416	
121197	96	
		121197

(3)

1B12-5-2

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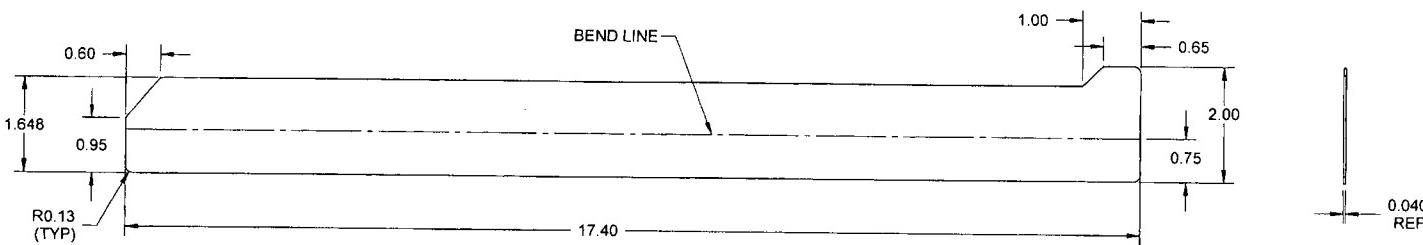
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84038

GRAIN
DIRECTION



D212-725-1-153F FLAT PATTERN

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
REF DART SPEC. M2024T3S0.040
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.12 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED			
MFG. APPR.		DRAWING NO.	REV. A
APPROVED		D4240	SHEET 6 OF 6
DE APPR.		TITLE	ANGLE
DATE	11.02.24	SCALE	NTS

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RELEASED
2011-08-25
MM

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DART AEROSPACE LTD	Work Order:	84038
Description: Angle	Part Number:	D212-725-1-153F
Inspection Dwg: D212-725-1 Pg 52 of 82	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	<u>R</u>	Audited by:	<u>S</u>	Preliminary Approval:	
Date:	12-5-2	Date:	12/06/02	Date:	

Rev	Date	Change	Revised by	Approved
A	10.11.15	New Issue	KJ	<i>[Signature]</i>

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